

Date: Thursday, 12/20/2007 3:21:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER
Job Number	: 36489			
Estimate Number	: 12959			
P.O. Number	: N/A		Part Number	: D36421 Rev b
This Issue	: 12/20/2007 S.O. No. : N/A		Drawing Number	: D3642 UNDER REVIEW
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: U/R B
Previous Run	: 34545		Material	: N/A
Written By			Due Date	: 1/10/2008
Checked & Approved By			Qty:	10
Comment	: Est Rev:A New Issue 07-07-20 JLM		Um:	Each
Verified By:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
	Comment: Qty.: 0.1747 sf(s)/Unit Total : 1.7472 sf(s) 2024-T3 .050 sheet Batch: 105646	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3642 Dwg Rev: B Prog Rev: B	
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/01/15
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36489

Part Number: D36421

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



12X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-F 08/01/12

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 1178

8/1/14 SD 12X

8.0 QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

12/08/10/15

Job Completion



a 08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36489
Description: Doubler	Part Number:	D3642-1
Inspection Dwg: D3642	Rev: AB	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

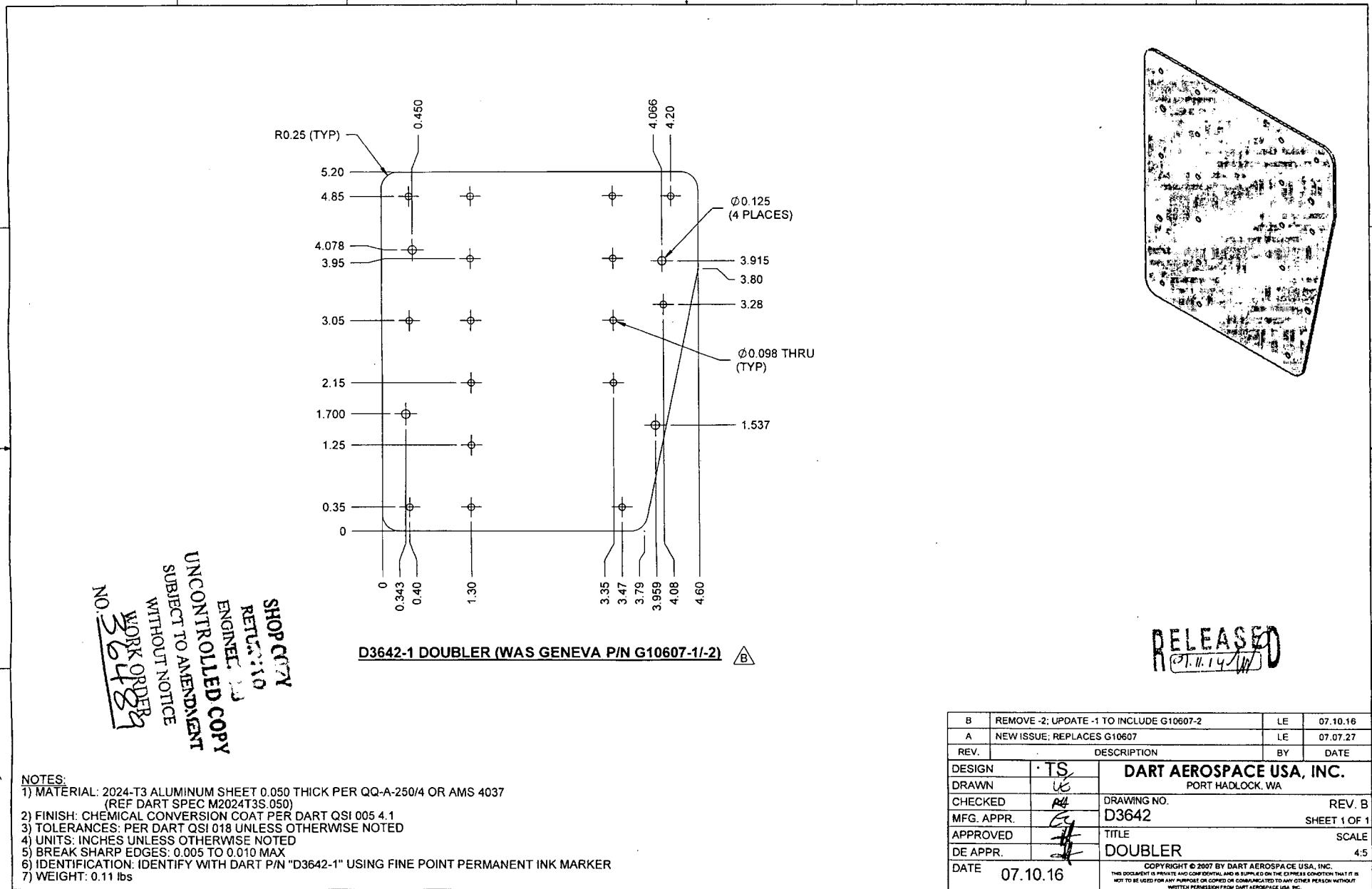
First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.126	X			
Ø0.098	+0.004/-0.001	.099	X			
0.35	+/-0.030	.35	X			
1.25	+/-0.030	1.25	X			
1.700	+/-0.010	1.703	X			
2.15	+/-0.030	2.15	X			
3.05	+/-0.030	3.05	X			
3.95	+/-0.030	3.95	X			
4.078	+/-0.010	4.078	X			
4.85	+/-0.030	4.853	X			
5.20	+/-0.030	5.209	X			
0.343	+/-0.010	.343	X			
0.40	+/-0.030	.403	X			
1.30	+/-0.030	1.36	X			
3.35	+/-0.030	3.35	X			
3.47	+/-0.030	3.472	X			
3.79	+/-0.030	3.79	X			
3.959	+/-0.010	3.959	X			
4.08	+/-0.030	4.08	X			
4.20	+/-0.030	4.20	X			
4.60	+/-0.030	4.60	X			
1.537	+/-0.010	1.539	X			
3.28	+/-0.030	3.28	X			
3.80	+/-0.030	3.80	X			
3.915	+/-0.010	3.918	X			

Measured by:	AB	Audited by:		Prototype Approval:	N/A
Date:	8-1-17	Date:	8/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AB

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1